

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013651**Date Inspected:** 19-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gang Wai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Out Side Segment Yard

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 9DW, weld No. SEG055D-164. The welder is identified as #066002. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-345-SMAW-3G (3F)-FCM-REPAIR-1. The weld repair report is B-WR-12046.

SMAW in the 4G position for the OBG Segment 9EW, weld No. SEG057B-006. The welder is identified as #205718. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G (4F)-FCM-REPAIR-1. The weld repair report is B-WR-11288.

BAY#14

This QA Inspector observed the following work in progress:

SMAW in the 3G position for the OBG Segment 11DE, weld No. SEG072D-061. The welder is identified as #215553. ZPMC QC is identified as Mr. Guo Pan. The welding variables recorded by QC appear to comply with WPS-B-P-2213-Tc-U4b-FCM.

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FCAW in the 2G position for the OBG Segment 12CE, weld No.FB3030-001-016. The welder is identified as #058551. ZPMC QC is identified as Mr. Guo Xing Hai. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

Ultrasonic Testing (UT)

This QA Inspector performed Ultrasonic testing (UT) 10% of the area previously tested and accepted by ZPMC Quality control personnel. This QA inspector generated a (UT) report for this date. The members are identified as U-rib to U-rib splice butt weld.

The Weld Designations are as follows

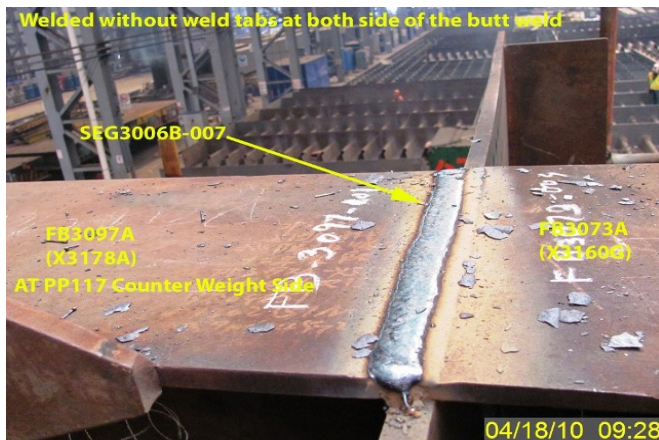
DP3007-001-039

DP3005-001-039

During the Quality Assurance Ultrasonic Testing (UT) scanned with miniature Transducer (2.25MHz) of welds located on Orthotropic Box Girder (OBG) segment 12AE, this Quality Assurance Inspector (QA) discovered the following issues that One (1) longitudinal Class “A” indication measuring approximately 15mm in length. The indication dbfs rating is “-2”. Material thickness is 12.5 mm for joint. The depth of the indication is approximately 9.2mm. The weld is identified as DP3007-001-039. The weld is designated as Non Seismic Performance Critical Material. The indication is clearly marked on or near the weld. The Y distance for this indication is 270mm from deck plate. The weld DP3007-001-039 is Complete Joint Penetration (CJP) Butt joint joining U-rib RS3001C (Non SPCM) to U-rib RS3001D (Non SPCM). Segment 12AE is located in Bay#14 work Shop. The Notice of Witness Inspection (NWIT) No. is 005546. The indication is located in an area previously tested and accepted by ZPMC Quality Control (QC) personnel.

This QA Inspector generated an incident report for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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